

Work Order ID 69984

Wednesday, May 25, 2011 10:32:55 AM



Page 1

Item ID: D3825-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket End)

Start Date: 5/25/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3825

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3825-1 rib as per dwg D3825

2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

SAD 11-05-25

6- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825

A/R S.S. Rod Batch: 115928

7- grind bushing weld flush where indicated on dwg D3825

8- deburr if necessary

6

PC 11-05-27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69984

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Page 2

Item ID: D3825-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket End)

Start Date: 5/25/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC Memo 0.00

Quality Control

BE
11.05.27

6 0

140 QC5- Inspect part completeness to step on W/O 0.00



QC Memo 0.00

Quality Control

8 11.05.27

(46)

150 Identify as per dwg & Stock Location: 3/c 0.00



Packaging Memo 0.00

Packaging

11.05.27

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Work Order ID 69984

Wednesday, May 25, 2011 10:32:55 AM

Page 3

Item ID: D3825-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib Assembly (Basket End)

Start Date: 5/25/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/3000

MF
11-05-29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 10:33:01 AM

Page 1

Work Order ID: 69984

Parent Item: D3825-041

Parent Item Name: Rib Assembly (Basket End)




Start Date: 5/25/2011

Required Date: 6/30/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3  Spacer Bushing		Manufactured	No			100	Each	17.0000	1	6			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>17</div> <div></div> </div>													
<div> <div>69436</div> <div>17</div> <div></div> </div>													
D3759-1  Bushing		Manufactured	No			100	Each	359.0000	1	6			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>200</div> <div></div> </div>													
<div> <div>69202</div> <div>200</div> <div></div> </div>													
<div> <div>WA005</div> <div>159</div> <div></div> </div>													
<div> <div>66489</div> <div>2</div> <div></div> </div>													
<div> <div>66870</div> <div>157</div> <div></div> </div>													
M304TS0.750W.065  304 SQ Tube .75x.75x.065W		Purchased	No			100	f	1,321.290	2.125	13.42105			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>MAT018</div> <div>1140.8565</div> <div></div> </div>													
<div> <div>117598</div> <div>1000</div> <div></div> </div>													
<div> <div>117636</div> <div>140.8565</div> <div></div> </div>													
<div> <div>WA007</div> <div>180.4339906</div> <div></div> </div>													
<div> <div>116267</div> <div>162.707172</div> <div></div> </div>													
<div> <div>116763</div> <div>17.7268186</div> <div></div> </div>													

6/11.05.27

6

6/11.05.27

6

SAD

11-05-25

13.4211

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

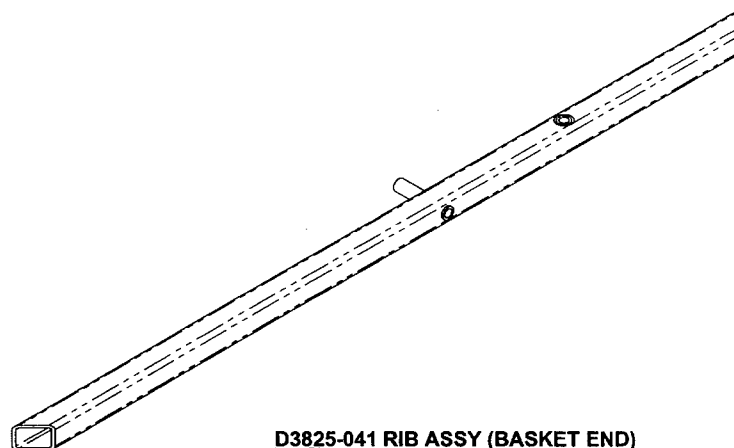
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ITEM	QTY	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB



D3825-041 RIB ASSY (BASKET END)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69984

P/11-05-25

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3825** REV. A
SHEET 1 OF 3

TITLE **RIB ASSY (BASKET END)** SCALE NTS

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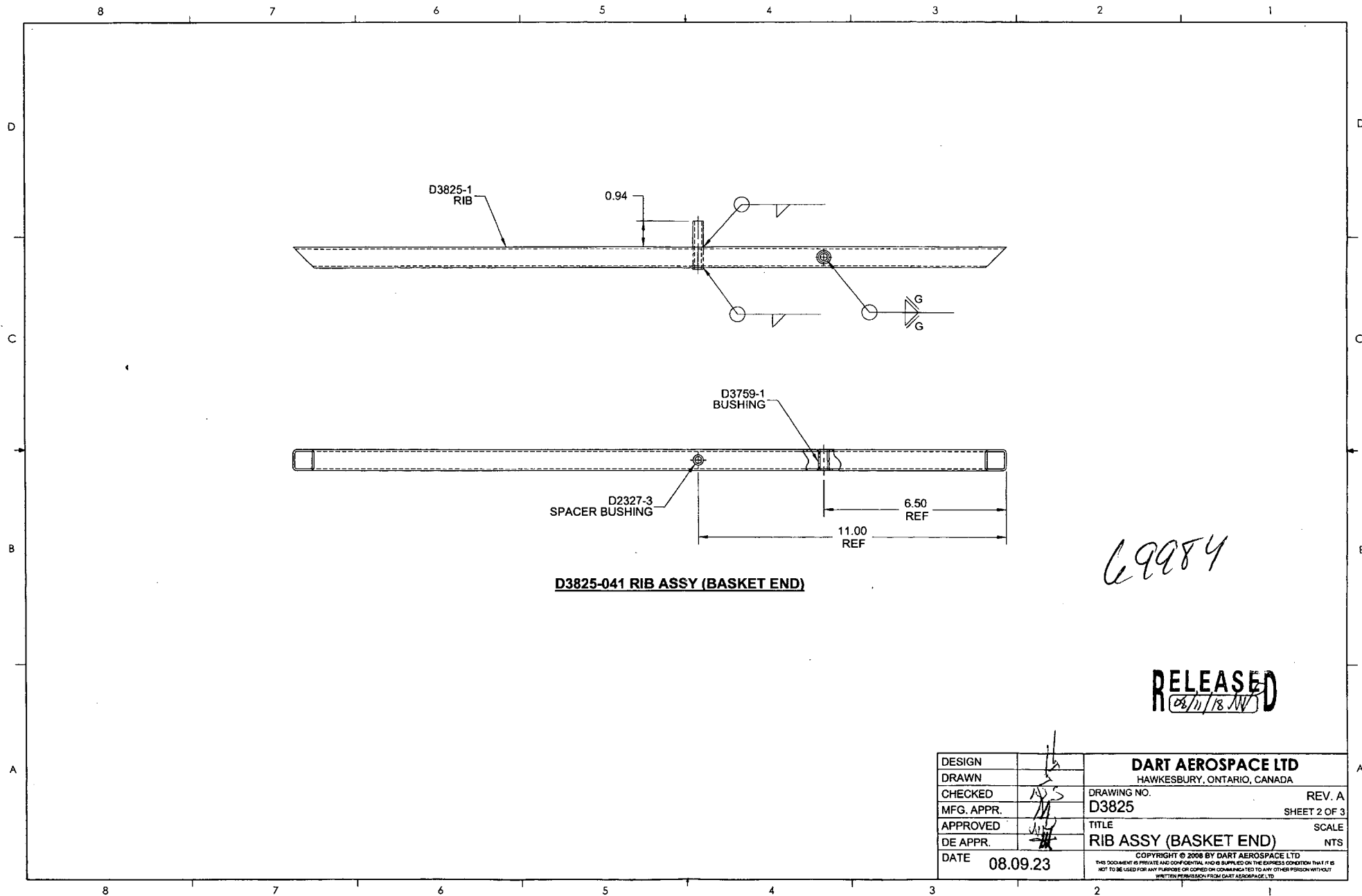
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NOTE: Date & initial all entries



RELEASED
08/11/18 NW

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
DATE	08.09.23	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

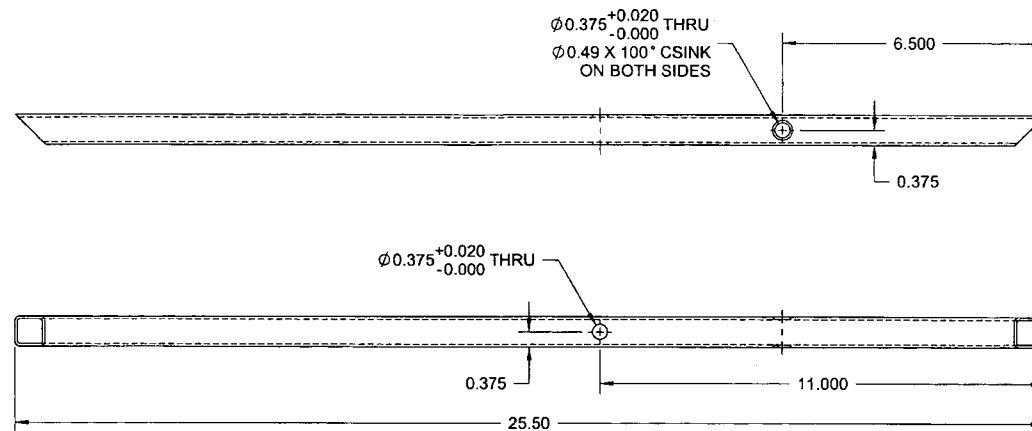
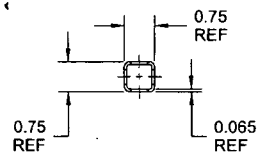
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NOTE: Date & initial all entries



D3825-1 RIB

69984

RELEASED
08/11/13

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.18 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
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